

Date: Wednesday, 03/09/2008 8:51:51 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 41703	
Estimate Number : 10530	
P.O. Number :	Part Number : D2571
This Issue : 03/09/2008 S.O. No. :	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 03/09/2008 Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 41587	Material :
Written By :	Due Date : 30/09/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08.9.03</u>	
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: B34875

JS 08/09/21 + 2 billet for replace scrap.

JLD 08/09/19

10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 41703 Double check by: DSP

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

JLD / JS 08/09/20

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

JLD JS 08/09/20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLD JS 08/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 08/07/25
 Resolution: Scrap Disposition: QA: N/C Closed: D Date: 08/09/25

NCR: <u>41703</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/20	2.0	2 part left on facing operation on the Y axis. RC Tooling	<u>[Signature]</u> 08/09/22	Scrap and Destroy and Replace Qty <u>(82)</u> B: 34875	<u>S.P.</u> 08/09/20	<u>[Signature]</u> 08/09/22	<u>[Signature]</u> 08/09/22	<u>[Signature]</u> 08/09/22

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 8:51:51 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 41703

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/09/22

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/09/22

(10X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
320°F
2:30

M-L

08/09/23

(10X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MS

08-09-23 (X10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 432

JS

08/09/24

(X10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/24

Job Completion



U 08.09.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41703
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.260	.259	.259	.258		
H	0.375	0.380		.377	.377	.377	.376		
I	0.490	0.510		.499	.497	.497	.497		
J	1.174	1.184		1.180	1.179	1.179	1.178		
K	0.558	0.578		.566	.564	.564	.568		
L	1.174	1.184		1.180	1.179	1.177	1.178		
M	1.490	1.500		1.493	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.876	3.874	3.873	3.873		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.252	.252	.252		
S	0.115	0.135		.135	.131	.133	.133		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.966	2.960	2.960	2.960		
V	0.230	0.250		.239	.237	.237	.237		
W	0.115	0.135		.128	.127	.127	.127		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.761	.761	.761	.760		
Z	0.352	0.372		.356	.355	.358	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.617	.618	.619	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.252	.252	.252		
AE	1.375	1.395		1.387	1.389	1.388	1.385		
AF	0.115	0.135		.131	.131	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.251	.250	.250		
AI	2.000	2.020		2.000	2.004	2.001	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>MR 188</i>
Date: 02/09/20

Audited by: <i>J.L</i>
Date: 08/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 41703	
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.563	.563	.563	.563		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.875	3.875	3.875		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.131	.131	.131	.131		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.127	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.127	.127	.126	.126		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.363	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: <i>JS</i>
Date: 08/09/21

Audited by: <i>JL</i>
Date: 08/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.002	8.000				
F	0.490	0.510		.495	.495				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.376	.376				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		.568	.568				
L	1.174	1.184		1.178	1.178				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.875	3.875				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.125	.125				
T	0.178	0.198		.185	.185				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.240	.240				
W	0.115	0.135		.125	.125				
X	0.308	0.313		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.360	.360				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.250	.250				
AH	0.240	0.260		.250	.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: <i>JP</i>
Date: 08/09/22

Audited by: <i>SL</i>
Date: 08/09/22




Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JP</i>

05-12-06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

 $\triangle E$

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2571
DATE 05.07.13		TITLE OUTER FWD SADDLE
		REV. SHEET 1 OF SCALE

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DETAIL C
SCALE 4:3

[illegible]

SECTION A-A

[illegible]

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